

Work Order ID 120159

June-09-14 11:33:43 AM

120159

Page 1

Item ID: D3290-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Frame

Start Date: 6/04/14

Start Qty: 30.00

30

Cust Item ID:

Required Date: 6/04/14

Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3290

Rev C

105

0.00

105

Purchasing

Purchasing

Memo

ISSUE PO 24574
CUT PER DRWG D3290 REV.C

0.00

CD 14/06/12 30

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Packaging

Memo

0.00

14/7/11 (30)

125

QC6- Inspect dimensions to drawing

0.00

125

QC

Quality Control

Memo

0.00

(30)

DAS

38

8-89

NOV 24 2014

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Item ID: D3290-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Frame
 Start Date: 6/04/14 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 6/04/14 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------------------|
| 130 *130* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | 30 | 0 | 14-11-25 | DAS 34 9-88 |
| 135 *135* QC Quality Control | QC7-Inspect Chemical Conversion Coat Memo | 0.00 0.00 | | | | (30) | | | DAS 38 9-89 NOV 26 2014 |
| 140 *140* Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 129828 Memo START TIME: 8:15 OVEN TEMPERATURE: 220- FINISH TIME: 9:10 | 0.00 0.00 | | | | 30 | 0 | 14-11-25 | DAS 34 9-89 |

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Item ID: D3290-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Frame

Start Date: 6/04/14

Start Qty: 30.00

30

Cust Item ID:

Required Date: 6/04/14

Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

30

NOV 28 2014

180

Identify as per dwg & Stock Location: 5432

0.00

180

Packaging

Memo

0.00

Packaging

30

NOV 28 2014

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

14/12/2

14-11-28

Picklist Print

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Work Order ID: 120159

120159

Parent Item: D3290-1

D3290-1

Parent Item Name: Frame

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A 12.06.13 NEW ISSUE DD VERF:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6S.063 | | Purchased | No | | | 100 | sf | 503.0880 | 3.75 | 119 | | | |

M6061T6S 063

6061-T6 .063 Sheet

**

C214/00/27

Location

Loc Qty

Loc Code

MAT021

503.088

M124446

3.7

M126075

4.5

M127006

9

M127420

117.12

M128054

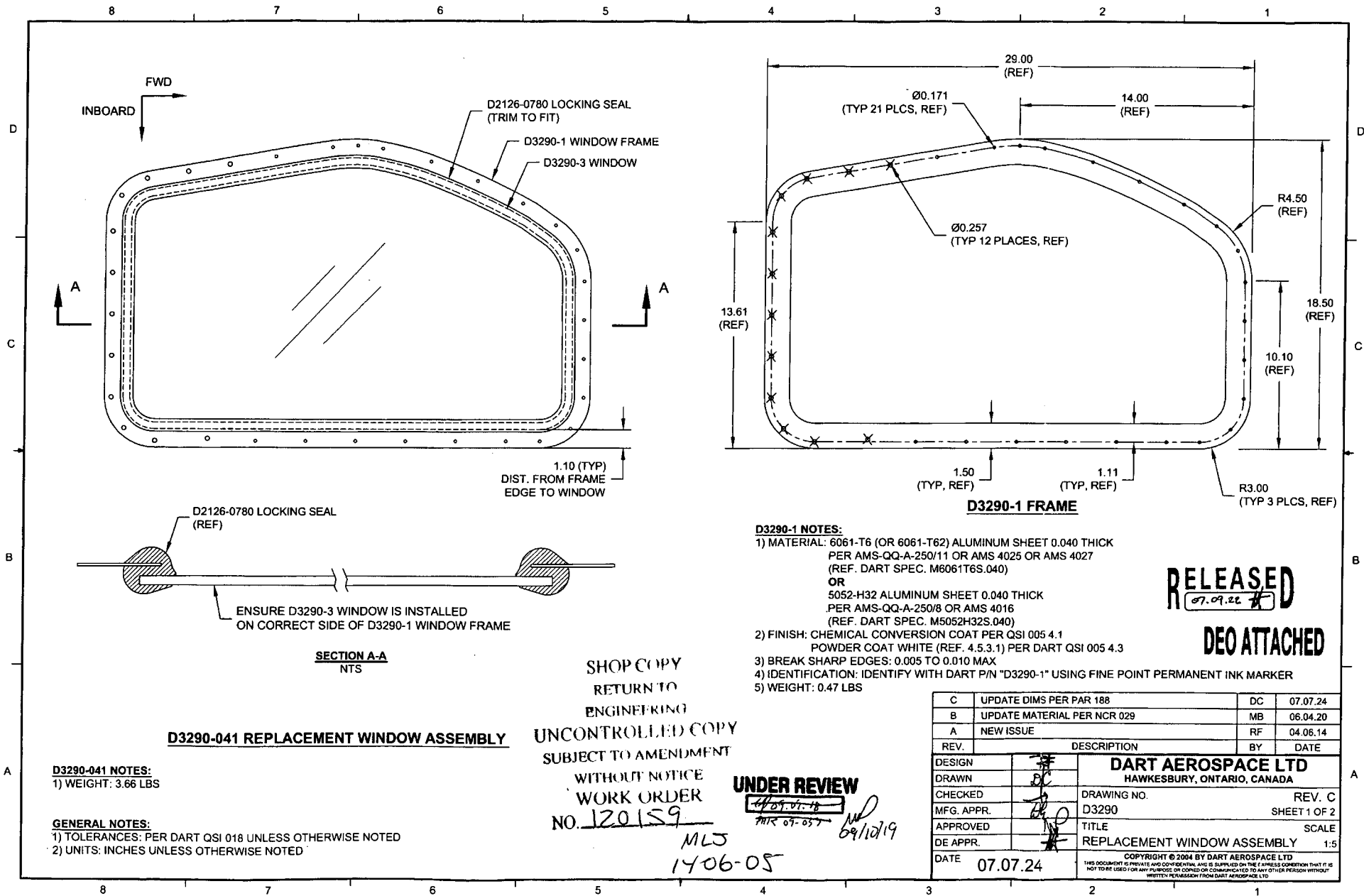
84.768

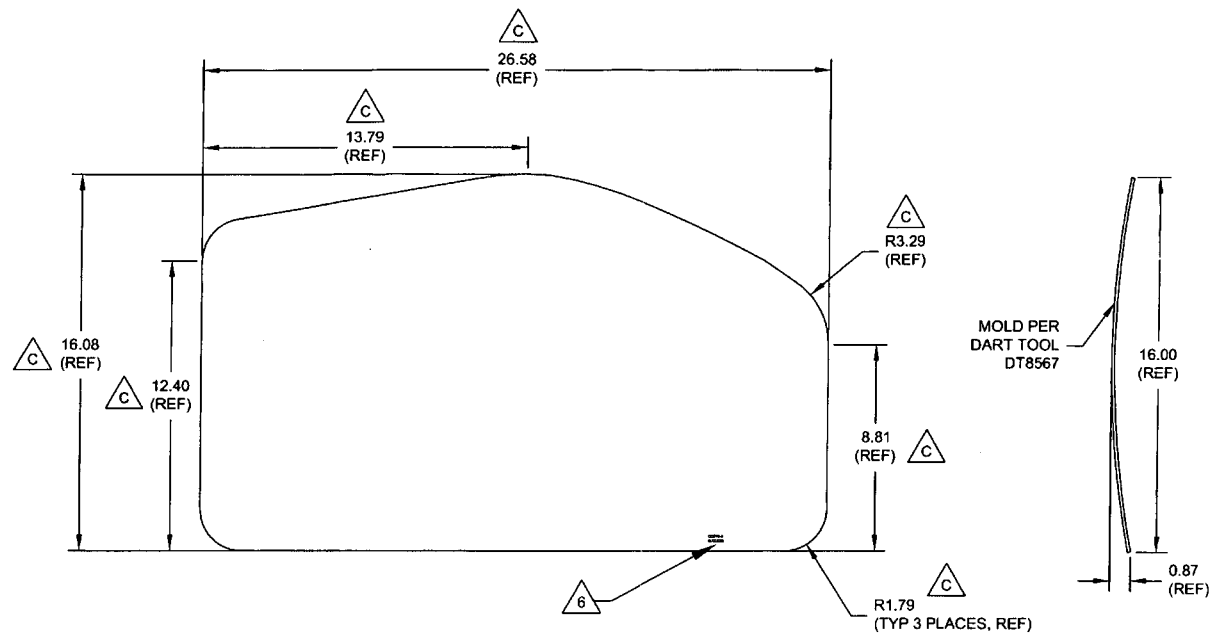
M128941

284

m127637

(119)





D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D3290 | SHEET 2 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | REPLACEMENT WINDOW ASSEMBLY | 1:5 |
| DATE | 07.07.24 | <small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

UNDER REVIEW

**DEO ATTACHED
RELEASED**

| | | | | | | | |
|----------------------|--------------------------------------|------------------------|---|--|-------------------------|---------------------------|--------------|
| DRAWING NO. D3290 | TITLE REPLACEMENT WINDOW ASSEMBLY | REV. C | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D3290-C-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN <i>q</i> | CHECKED <i>b</i> | MFG. APPR. <i>E</i> | APPROVED <i>AD</i> | | DE APPR. <i>#</i> | | |
| DATE 09.09.18 | DATE 09.09.18 | DATE 09.09.18 | DATE 09/09/21 | | DATE 09/09/21 | | |

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009 -10- 09
WMP

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T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6192
Date: 2014-07-10
Page: 1

| | |
|---|---|
| Sold to: | Ship to: |
| Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada | Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada |
| Order No.: 24574 | Sold By: JONATHAN LESSARD |
| Shipped By: | Ship Date: 2014-07-10 |
| Tracking No.: | |

| Item No. | Unit | Description | Quantity |
|----------|--------|--------------------------------------|----------|
| 646.3711 | Chaque | 646.3711 clip | 40 |
| 646.3712 | Chaque | 646.3712 clip | 20 |
| 646.3712 | Chaque | 646.3712 clip | 40 |
| 646.3713 | Chaque | 646.3713 gusset | 40 |
| 646.3714 | Chaque | 646.3714 gusset | 40 |
| 646.3717 | Chaque | 646.3717 doubler | 30 |
| 646.3719 | Chaque | 646.3719 doubler | 20 |
| 646.3719 | Chaque | 646.3719 doubler | 40 |
| d2365 | Chaque | d2365 wearplate pin | 30 |
| d3283-1 | Chaque | d3283-1 doubler | 40 |
| d3208-3 | Chaque | d3208-3 pedal mount angle | 20 |
| d3290-1 | Chaque | d3290-1 frame | 30 |
| d3302-1 | Chaque | d3302-1 doubler | 10 |
| d3302-3 | Chaque | d3302-3 doubler | 10 |
| d3363-1 | Chaque | d3363-1 console | 16 |
| d4072-3 | Chaque | d4072-3 airframe hinge backing plate | 40 |
| d4073-3 | Chaque | d4073-3 door hinge backing plate | 50 |
| d4074-5 | Chaque | d4074-5 backing plate | 40 |
| d4610-5 | Chaque | d4610-5 shim | 20 |

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days